

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009335**Date Inspected:** 24-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Hu Wei Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY #1

Magnetic Particle inspection

This Q.A Inspector performed Magnetic Particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the Floor Beam Designation are as follows.

FB204-013-56, 67, 68, 22, 23, 16, 44, 41, 42, 40, 43, 46

FB204-015-55, 56, 67, 19, 20, 14, 45, 38, 39, 21, 43, 37

FB205-014-46, 28, 34, 02, 03, 10, 17, 18, 23, 06, 12, 16

FB204-013-52, 61, 62, 03, 10, 11, 26, 32, 33, 25, 31, 34

FB204-014-52, 61, 62, 03, 10, 11, 27, 32, 33, 06, 12, 34

FB204-016-55, 56, 67, 23, 16, 17, 44, 45, 38, 18, 43, 37

BAY#2

Magnetic Particle inspection

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This Q.A Inspector performed Magnetic Particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the Floor Beam Designation are as follows.

FB012-029-02, 010, 013, 014, 021, 048

FB012-030-02,010, 013, 014, 021, 047

BAY#3

Magnetic Particle inspection

This Q.A Inspector performed Magnetic Particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the Floor Beam Designation are as follows.

FB010-040-02,010, 013, 014, 021, 047

FB015-046-02,010, 013, 014, 021, 048

FB010-034-02,010, 013, 014, 038, 048

FB015-043-02,010, 013, 014, 021, 048

BAY#3

Green Tag

The following green tags issued for OBG components after completing the NDT requirements are:

1. FB010-034-Green tag No-009574
2. FB010-040-Green tag No-009575
3. FB015-043-Green tag No-009576
4. FB015-046-Green tag No-009577

BAY#03

This QA Inspector randomly observed the following work in progress

FCAW welding process of weld joint 46 located on PCMK FB011-039. Welder is identified as 044790 ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3

FCAW welding process of weld joint 13 located on PCMK FB009-039. Welder is identified as 208035 ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

FCAW welding process of weld joint 31 located on PCMK CA63. Welder is identified as 044830 ZPMC QC is

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identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

FCAW welding process of weld joint 097 located on PCMK CSD6-PP78. Welder is identified as 204338 ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3

FCAW welding process of weld joint 132 located on PCMK SSD20A-PP101. Welder is identified as 044824 ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4B-F.

BAY#2

This QA Inspector randomly observed the following work in progress

FCAW welding process of weld joint 003 located on PCMK LD001-033. Welder is identified as 215676 ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

FCAW welding process of weld joint 003 located on PCMK LD001-034. Welder is identified as 045260 ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
